

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002121**Date Inspected:** 13-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Erik Prue was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

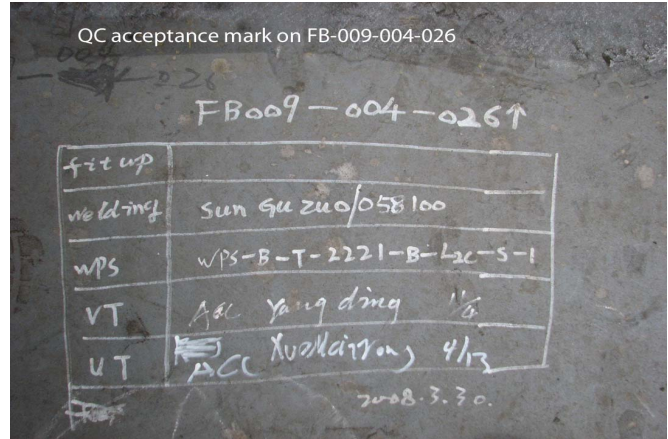
Bay 7- QA Inspector observed ZPMC QC UT Inspector Xue Mai Vong perform ultrasonic testing on Floor Beam Sub Assembly Complete Joint Penetration (CJP) transition Butt joint at weld joint FB016-007-026, FB010-005-026, FB009-004-026, FB016-005-026, FB002-005-026, FB009-001-026, FB010-004-026, FB015-010-026, FB010-003-026, FB015-014-026, FB010-007-026, FB010-008-026, FB015-008-026, FB001-005-026, FB009-008-026, and FB010-006-026. QA Inspector performed 10% minimum QA UT verification of the above QC acceptable welds. The weld and base metal were scanned utilizing a Krautkramer Branson USN 60 #01RN5T. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 70 degree angle wedge from face A. For details please see the ultrasonic testing report TL-6027 dated April 13, 2008. QA Inspector found QC UT inspection method and welds inspected to be in compliance with AWS D1.5- 2002 Table 6.3 and the contract documents.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

QA Inspector discussed with ZPMC QC Inspector Xue Mai Vong about scanning levels while UT inspecting Floor Beam welds between the 12mm by 30mm transition CJP Butt welds. QA Inspector explained that in accordance with AWS D1.5 (02) table 6.3 the 12mm thick section needed to be scanned 20 Db's above reference and the 30mm section needed to be scanned 25 Db's above reference. QC inspector agreed and was scanning at the correct levels for the different thickness of base material.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 858 344-2712, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prue,Erik	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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